

Work Order ID 65833

Wednesday, January 26, 2011 11:31:08 AM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*M*Date: *11-01-26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3017

Rev B

100

Weld per dwg A/R 4130 rod Batch: *M100075* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

EL 11-3-30 *(X1)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 *Ø* *BE 11/03/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID:	D3017-041	Accept		Setup	Start	
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Start Date:	1/26/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/7/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>70</u>			
130 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3,5.6) per QSI005 4.3 <u>m 11/3/28</u> Memo START TIME: <u>7:10</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>7:40</u>	0.00 0.00				<u>1</u>	<u>BL 11-3-31</u>		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1</u>	<u>φ</u>	<u>11/03/31</u>	

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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

W6
65831 (11)

0.00

Packaging

JS 11/03/31 (C)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31 MFMF
11-03-31

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Picklist Print

Wednesday, January 26, 2011 11:31:15 AM

Page 1

Work Order ID: 65833

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly





Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 		Purchased	No			100	f	9.0000	2.458	2.587368			
4130 RD Tube .750 x.083W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT33		9							
				113812		9							
M4130NT0.750W.049 		Purchased	No			100	f	105.5417	11.125	11.71053			
4130 RD Tube .750 x.049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		105.5417							
				10133		13							
				110740		92.5417							
D3017-11 		Manufactured	No			100	Each	17.0000	2	2			
cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		17							
				52583		17							
D3017-7 		Manufactured	No			100	Each	16.0000	3	3			
Lug													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		16							
				38567		2							
				52915		14							

EL 11-3-28

2.5

EL 11-3-28

11

EL 11-3-30

2

EL 11-3-30

3

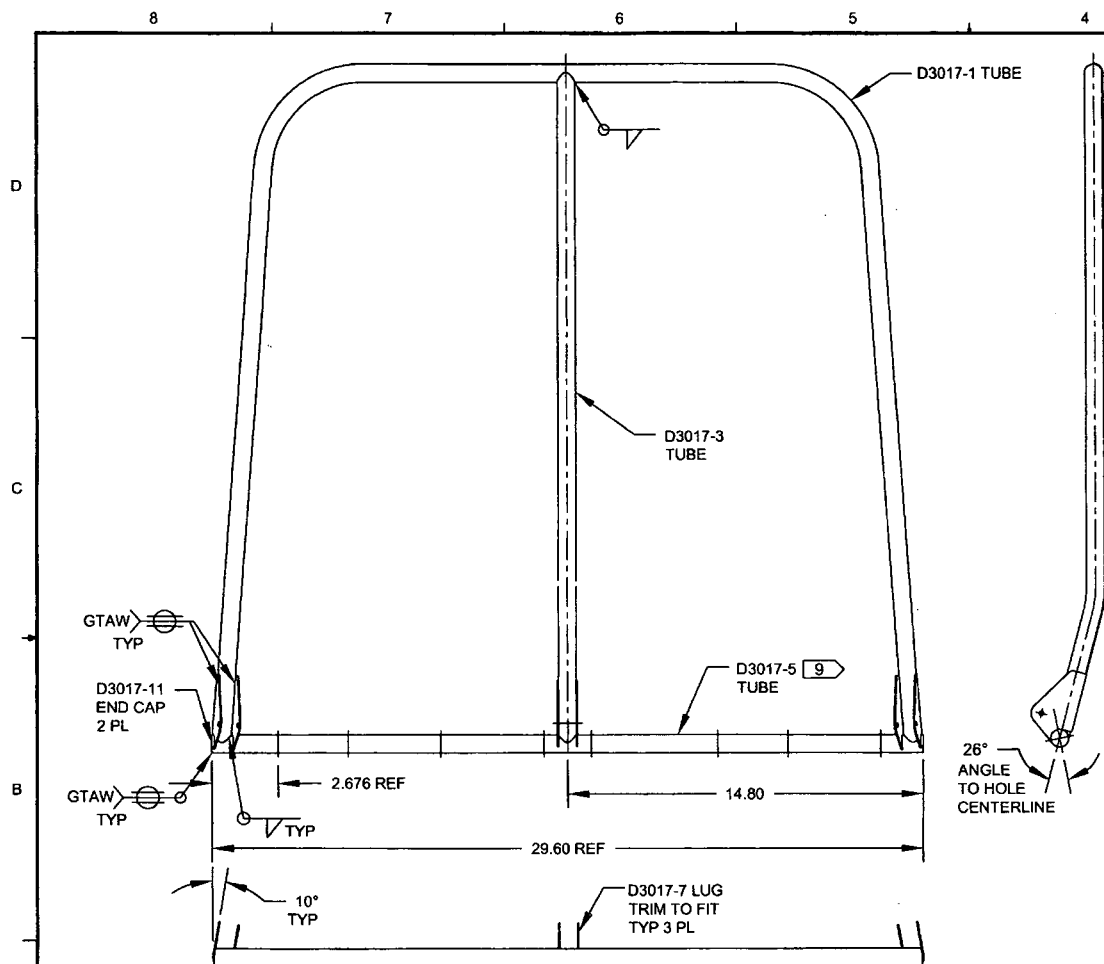
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65883
RD11-01-26

RELEASED
2010-02-02
WJP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3017
TITLE BACK FRAME ASSEMBLY
REV. B
SHEET 1 OF 4
SCALE NTS

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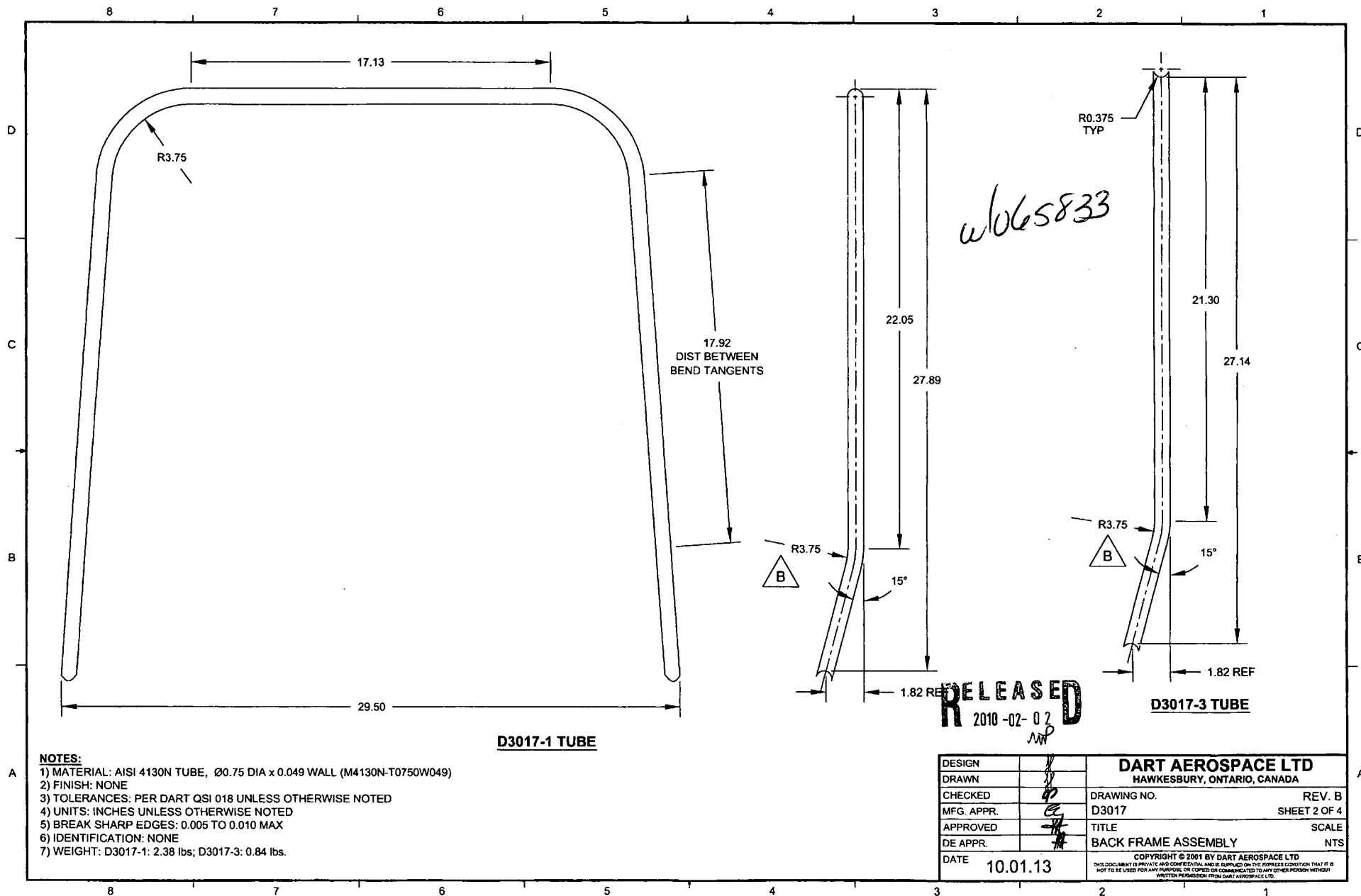
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NOTE: Date & initial all entries



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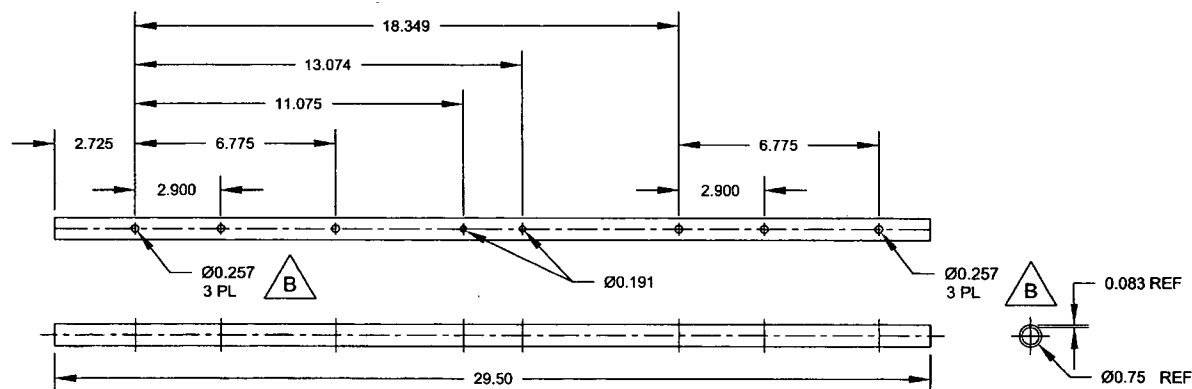
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NOTE: Date & initial all entries

u1065833



D3017-5 TUBE

RELEASED
2010-02-02
AMP

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, $\varnothing 0.75$ DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



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MFG. APPR.		D3017	SHEET 3 OF 4
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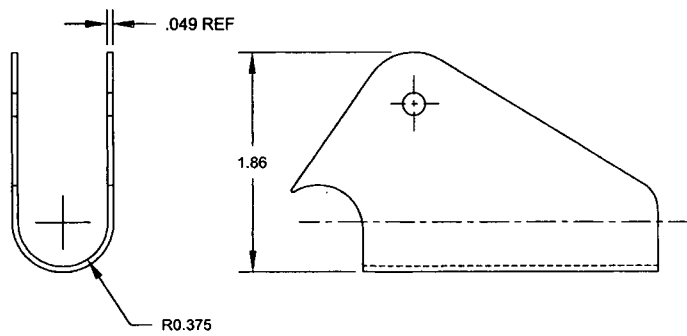
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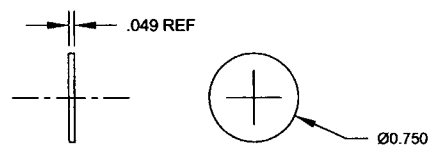
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

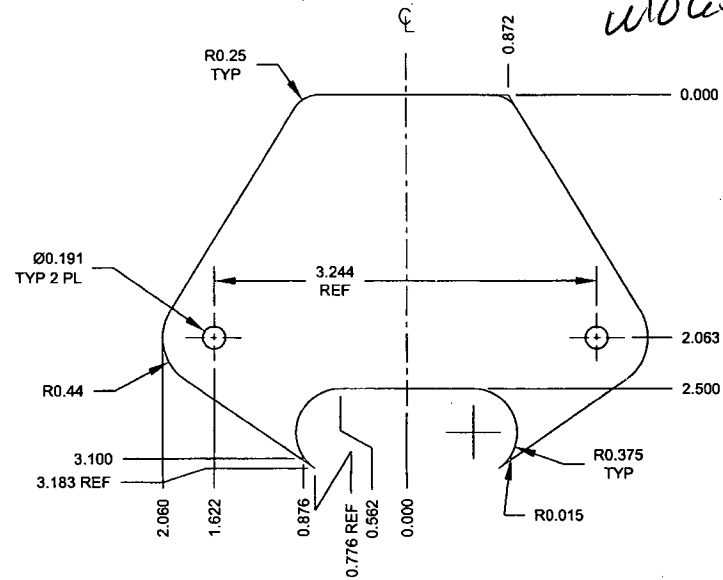
u065833



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02
JMP

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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MFG. APPR.	<i>[Signature]</i>	D3017	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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